User

Wednesday, 3/26/2008 9:34:02 AM

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

Estimate Number

: 38150

: 10383

P.O. Number

Prsht Rev.

: 3/26/2008 This issue

: NC

First Issue

Previous Run

: // : 37930

Type

S.O. No. :

: SMALL /MED FAB

Drawing Revision Material

Drawing Name

Part Number

Drawing Number

Project Number

Due Date

: N/A : B

: D30661

D3066 REV.B

: SPACER

: 4/1/2008

60 Um:

Each

Written By

Checked & Approved By Comment

: Est;C 02.11.01

Incorporated D3066-1 IPP KJ/RF

Est Rev:B

Now M6061-T6 06-06-23 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 .080 Sheet

1.0

M6061T6S080

6.2

5.9535 sf(s)

Comment: Qty.: 0.0992 sf(s)/Unit Total:

Material: 6061-T6 0.080" thick

(M6061T6S.080) Batch: 102732 x37 B 8-3-31

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3066 Dwa Rev: Prog Rev:

B 8-3-31

2-Deburr if necessary

3.0

20

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

189-3-31

PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES					
DATE	STEP	PROCI	EDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
•									
				•					
Part No	:	PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	Date: _	
					QA:	N/C Close	d:	Date:	
NCR:		W	ORK ORDER NON-CON	FORMANCE	E (NC	R)	***************************************		
			Corrective Actio	n Section B					

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
		Description of NC Corrective Action			Section B		Approval	Ammanal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspecto
							<u>{</u>	

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:34:02 AM User: Kim Johnston **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 38150 Part Number: D30661 Job Number: Description: Seq. #: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE # Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WH FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE mf 08-04-81 Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
						:			
Part No	:	PAR #: Fault Category: N	ICR: Yes	No DC	A:	Date: _			
			QA:	N/C Close	ed:	Date: _			
NCR:		WORK ORDER NON-CONFORMANO	CE (NC	R)					

NCR:		V	VORK ORI	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B			Annroyal	Ammourel
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38150
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST									
		X First A	Article	Prof	otype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
Ø0.128	+0.005 -0.000	.129	*						
0.708	+/-0.010	265,	*						
0.358	+/0.010	;354	*						
0.350	+/0.010	, 354	X-						
2.250 (Pitch)	+/-0.005	2.750	A						
16.450	+/0.010	16.450	X						
						Alberta, b. T. S.			
			,						

Measured by:	Audited by:		Prototype Approval:	N/A
Date: 9-3-31	Date:	08/03/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	06.06.23	Dwg Rev. changed	KJ/JLM	411
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DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B CHECKED APPROVED. D3066 SHEET 1 OF 1 DATE TITLE SCALE 06.05.29 **SPACER** 1:3 Α 02.09.11 **NEW ISSUE**

ADD 6061-T6 MATERIAL

RELEASED

В

06.05.29

-0.0000.354 - 2.600 4.850 7.100 - 9.350 \emptyset 0.128 (#30) (TYP 8 PLACES) - 11.600 SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY - 13.850 SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 16.096 16.450 0.708 R0.354 (TYP) 0.354 -

D3066-1 SPACER

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

ÒR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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